

20

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	20700
<b>Description:</b> Hinge Bracket	<b>Part Number:</b>	D2857-1
<b>Drawing:</b> D2857 Rev. A1	<b>Qty:</b>	24

RT 03.09.05

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	HA	04.04.13	24
2	METAL	Cut blanks 5.2" Material: 2.00" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) Batch 711706 3mR 04/04/13	HA	04/04/13	24
3	HAAS	Machine per folio D2857-1	SA	04/04/13	24
4	QC	Inspect Level 2	SA	04/04/13	24
5	METAL	Tumble Deburr any rough edges after tumbling	SA	04/04/13	24
6	METAL	Acid etch and alodine as per QSI 005 4.3	ML	04.05.05	24
7	QC	Inspect Level 7	SA	04.05.05	24
8	FINISHING	Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3	ML	14.05.06	24
9	QC	Inspect Level 3	SA	04.05.06	24
10	STORES	Identify and stock	SA	04/05/06	24
11	EXPEDITING	Close W/O Cost / Part: 19.85 545 04/05/00 (24) 20.23	HA	04.05.11	24

Rev	Date	Change	Revised By	Approved
A	99.01.04	New	KS	
B	99.03.25	Added tumble and acid etch	DM	
C	00.06.22	Removed P/O for powder coat	EC	

RELEASED

JUN 26 2009

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Intial					
<del>11/13/03</del>								

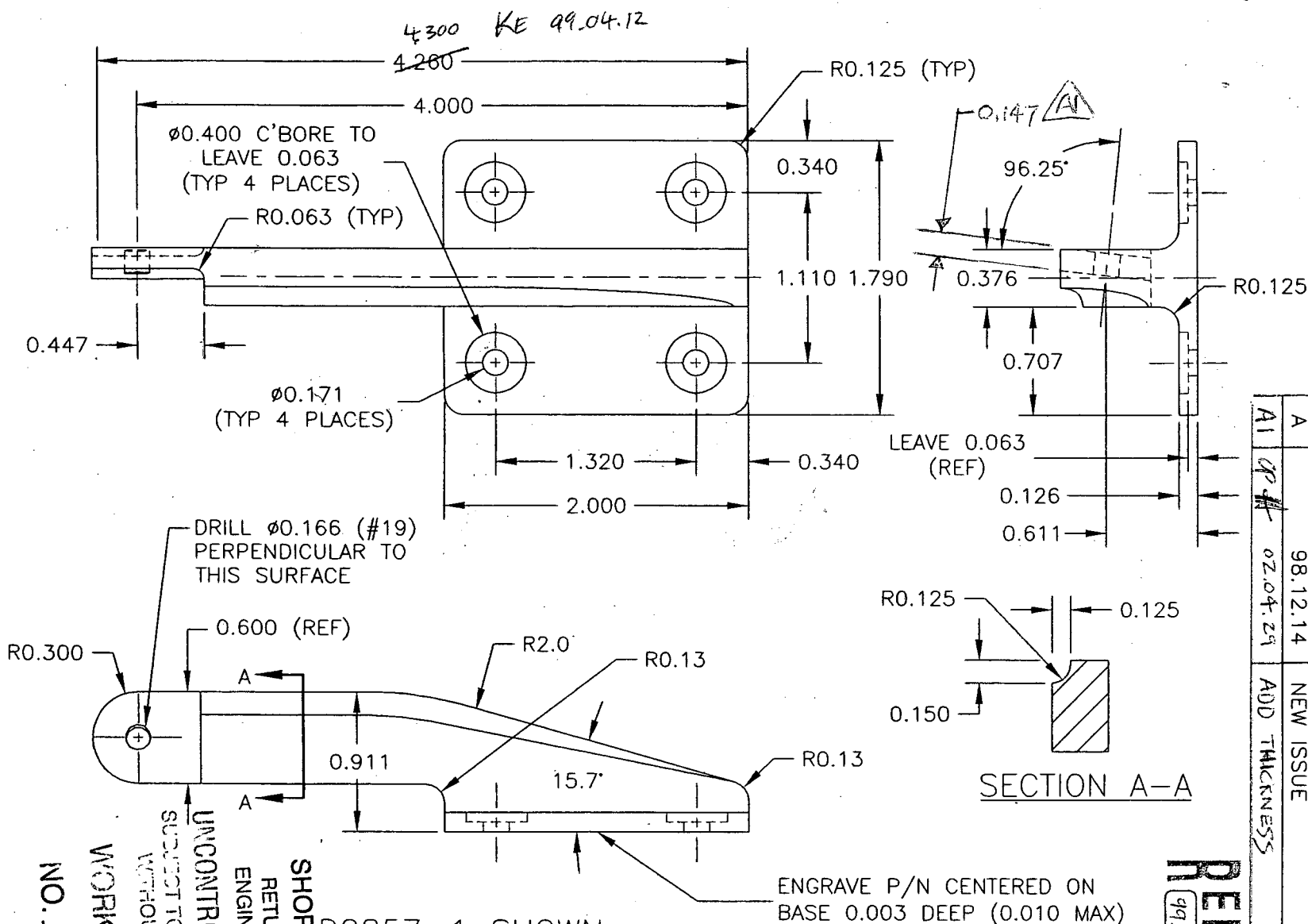
PAR#: \_\_\_\_\_ Fault Category: \_\_\_\_\_ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

QA COPY ISSUED

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. A
KE	KE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KE	KE	D2857	
DATE	TITLE	SCALE	
98.12.14	HINGE BRACKET	1:1	
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
A1	02.04.29	ADD THICKNESS	



D2857-1 SHOWN  
D2857-2 OPPOSITE

RELEASED  
99.01.06 KE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)  
FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
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UNCONTROLLED COPY  
SUSCEPTIBLE TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 20700

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Apr 12, 2004  
03:42 pm

Work Order No : 0020700  
Project Name : D2857-1  
Project For : WK420  
Work Order Type : Main  
Main WO Number :  
House Part Number : D2857-1  
Description : Hinge Bracket  
Manufactured : Yes  
Amount Req'd : 24  
Amount Done : 0  
Start Date : 04-12-04  
Est Finish Date : 05-12-04  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order: 20700
Description: wing bracket		Part Number: D857-1
Inspection Dwg:	Rev:	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	$\pm 0.010$	4.308	✓			
.340	"	.339	✓			
1.110	$\pm 0.005$	1.111	✓			
1.790	$\pm 0.010$	1.793	✓			
1.320	$\pm 0.005$	1.319	✓			
2.000	$\pm 0.010$	2.003	✓			
0.171	$\pm 0.008$	.171	✓			
<hr/>						
.147	$\pm 0.010$	.146	✓			
.376	"	.375	✓			
.126	"	.125	✓			
<del>.126</del>	"					
.063	"	.063	✓			
<hr/>						
.166	$\pm 0.008$	.167	✓			
.911	$\pm 0.010$	.909	✓			
.600	"	.599	✓			
<hr/>						
.125	$\pm 0.010$	.132	✓			
.150	"	.154	✓			

Measured by: <i>SP</i>	Audited by: <i>EL</i>	Prototype Approval: <i>N/A</i>
Date: <i>07/10/17</i>	Date: <i>07/14/17</i>	Date: <i>N/A</i>
Rev: A	Date:	Change: New Issue
Revised by: KJ/RF	Approved:	